



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7401

Job Sheet 214635



Part No: 647.7401

Job Qty: 3 pcs

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/28/20

Job Tracking No:

Due Date: 11/16/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Packaging 1 - Pick Kit	3 pcs		11/14/20	0.00	0.00	Packaging 1 - SCH-S			DAS 58 9-89 NOV 30 2020
120	Small Fab - 2 - B4B	3 pcs		11/16/20	0.00	3.26	Small Fab - 1 - B4B			DAS 58 9-89 DEC 01 2020
							Small Fab - 2 - B4B			
							Small Fab - 3 - B4B			
							Small Fab - 4 - B4B			
							Small Fab - 5 - B4B			
							Small Fab - 6 - B4B			
							Small Fab - 7 - B4B			
							Small Fab - 8 - B4B			
							Small Fab - 9 - B4B			
							Small Fab - Various 1 - B4B			
130	QC 5	3 pcs		11/16/20	0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
							QC 5 - 61			
							QC 5 - 81			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S317245



Part: 647.7401

Job No: 214635

Serial No/Batch: S317245

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/30/20

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140 Packaging 3-1 - Stock - B4B	3 pcs	11/16/20	0.00 0.00	QC 5 - 82	DEC 02 2020
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	3 pcs	11/16/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. A/R RTV LOCTITE

598: 5304317 exp. date: 08/22

130 - QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

150 - (QC21- Final Inspection - Work Order Release)

CK06
 CK07A
 CK07A
 CK114
 GA011
 ST303
 GA015
 ST277
 ST280
 ST263
 ST263

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3015	Blade	6 pcs (2 ea)	110-Packaging 1 - Pick Kit	S311540
647.7610	Upper Deflector	3 pcs (1 ea)	110-Packaging 1 - Pick Kit	S304129
647.7810	Bracket A	3 pcs (1 ea)	110-Packaging 1 - Pick Kit	S309508
647.7811	Bracket B	3 pcs (1 ea)	110-Packaging 1 - Pick Kit	S304976
647.7812	Center Plate, Upper	3 pcs (1 ea)	110-Packaging 1 - Pick Kit	S223882
MS21042-3	Nut use MS21042L3 per QSI 017	9 Ea (3 ea)	110-Packaging 1 - Pick Kit	S309678
MS21042L08	Nut	39 Ea (13 ea)	110-Packaging 1 - Pick Kit	S307361
MS27039-08-19	Screw	18 Ea (6 ea)	110-Packaging 1 - Pick Kit	S316219
MS27039-08-23	Screw	21 Ea (7 ea)	110-Packaging 1 - Pick Kit	S280571
MS27039-1-19	Screw	9 Ea (3 ea)	110-Packaging 1 - Pick Kit	S248085
NAS1149F0332P	Washer (AN960-10L)	18 Ea (6 ea)	110-Packaging 1 - Pick Kit	S209801
NAS1149FN832P	Washer (AN960-8)	204 Ea (68 ea)	110-Packaging 1 - Pick Kit	S309680

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.3015	6	6	0
	647.7610	3	8	0
	647.7810	3	8	0
	647.7811	3	8	0
	647.7812	3	10	0
	MS21042-3	9	393	0
	MS21042L08	39	2,275	0
	MS27039-08-19	18	249	0
	MS27039-08-23	21	67	0
	MS27039-1-19	9	203	0
	NAS1149F0332P	18	1,369	0
	NAS1149FN832P	204	594	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QS1042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			